



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4766-041-BENT
Job Sheet 199932



Part No: D4766-041-BENT

Job Qty: 1 pcs

Part Name: Extrusion Bent



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Due Date: 9/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP REV:A 16.05.16 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs	9/18/19	9/18/19	0.00	1.49	Skidtubes - Bend	MLA TF	
120	QC 5	1 pcs	9/18/19	9/18/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	9/18/19	9/18/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



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CANADA
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Container No: S213549



Part: D4766 - 041 - BENT

Job No: 199932

Serial No/Batch: S213549

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/13/19

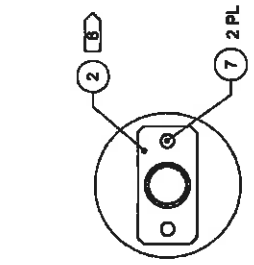
Plex 9/5/19 7:35 AM Dart.lajeunesse.marie

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	9/18/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 110 - Skid tubes - 1- Bend FWD end as per dwg and folio 2- Cut FWD end as per dwg using DT8185 ***VERIFY Descriptions: MESUREMENT**** 120 - QC5- Inspect part completeness to step on W/O 130 - Identify as per dwg & Stock Location: <u>LG008</u> 140 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2962-190	Extrusion	1 pcs (1 ea)	110-Skid tubes - Bend - 1	<u>5155/45</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Skid tubes - Bend - 1	D2962-190	1	42	0	
Part Specifications					
Specifications could not be found.					

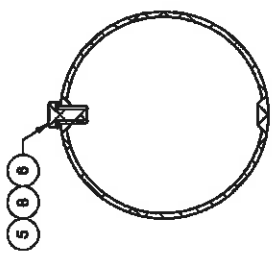
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8 7 6 5 4 3 2 1

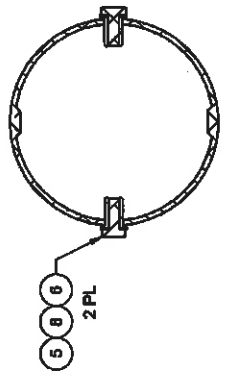
ITEM	QTY	PIN	DESCRIPTION
1	11	D4766-043	SKIDTUBE SUB ASSY
2	22	D4688-1	SPACER
3	1	D4763-1	DOUBLER
4	2	D4766-045	SKIDTUBE SUB ASSY
5	3	D6304-1	CROSSBOLT SPACER
6	3	AELS-1032-130	INSERT
7	64	AN824A	BOLT
8	3	MS20601AD4W3	RIVET, BLIND, CSK
9	3	NAS1149C032R	WASHER



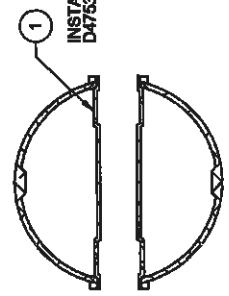
DETAIL E
SCALE 8X
22 PL



SECTION D-D
SCALE 8X

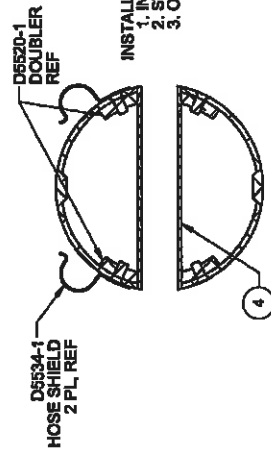


SECTION F-F
SCALE 8X



INSTALL D4688-1 SPACER AFTER INSTALLING D4763-1 DOUBLERS AS FOLLOWS (11 PL)

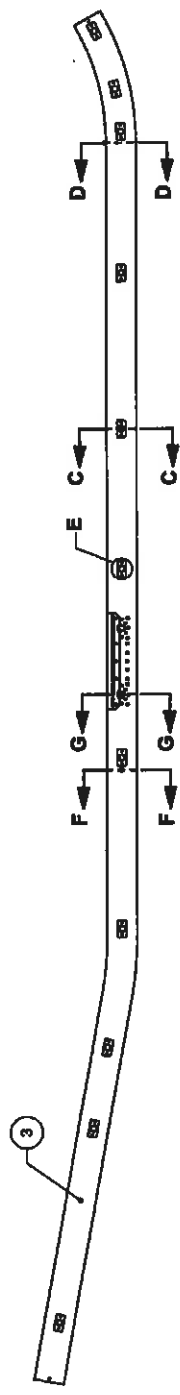
1. INSERT D4688-1 SPACER
2. SWAGE TO $\phi 0.650 \pm 0.010$ -0.000 X 1.0 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



SECTION G-G
SCALE 8X
2 PL

INSTALL D6304-1 SPACER AS FOLLOWS (2 PL)

1. INSERT D6304-1 SPACER
2. SWAGE TO $\phi 0.585 \pm 0.005$ -0.000 X 1.0 DP PER QSI 002
3. OPEN THRU HOLE TO $\phi 0.625$



D4766-043 SKIDTUBE SUB ASSY

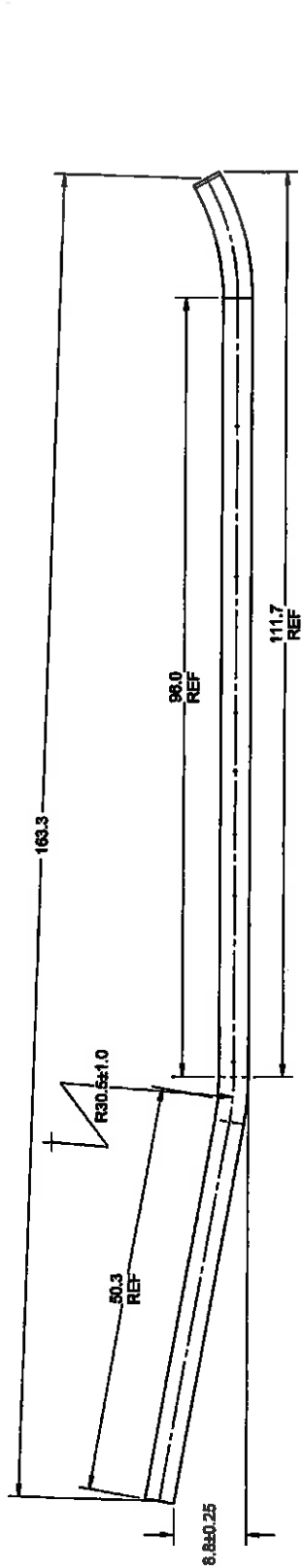
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 33.9 lbs
 - 8) SEAL FAYING SURFACES USING PROSEAL P/S 880/1422 OR MIL-S-8802 CLASS B2 SEALANT

DESIGN	AP	AP	DART AEROSPACE USA, INC.
DRAWN	ALS	ALS	EUGENE, OR
CHECKED	ML	ML	DRAWING NO.
MFG. APPR.	DP	DP	D4766
APPROVED	WM	WM	TITLE
DE APPR.	DS	DS	SKIDTUBE
DATE	17.03.30	17.03.30	SCALE
			NTS

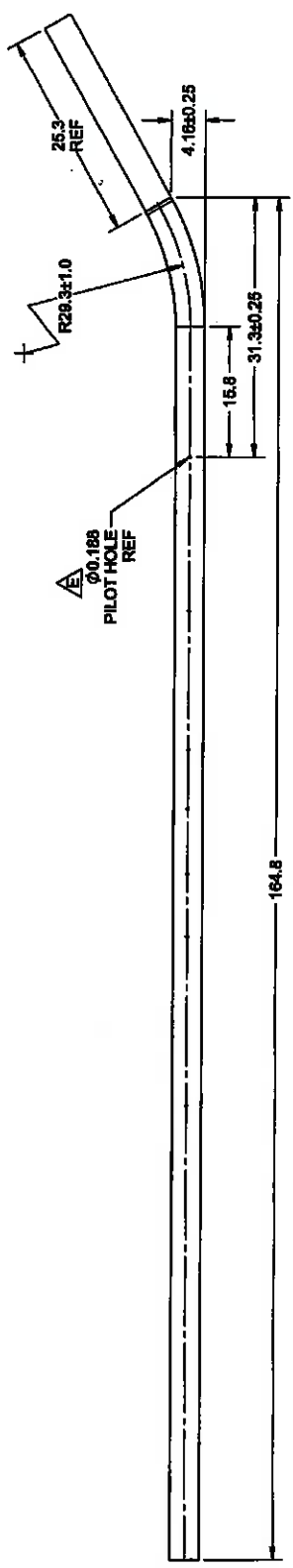
APPROVED
RELEASED
2017-08-11

REVISIONS
REV. E
SHEET 3 OF 7
SCALE
NTS

8 7 6 5 4 3 2 1



D4768-045 SKIDTUBE SUB ASSY
(BENDING DETAIL, AFT BEND)



D4768-045 SKIDTUBE SUB ASSY
(BENDING DETAIL, FWD BEND)

DESIGN	AP	AJS	ML	DP	WM	DS	DATE	17.03.30
DRAWN								
CHECKED								
APPROVED								
DATE								
DART AEROSPACE USA, INC.								
EUGENE, OR								
DRAWING NO. D4768								REV. E
TITLE SKIDTUBE								SHEET 5 OF 7
DATE 17.03.30								SCALE NTS
CONFIDENTIAL & NOT FOR RELEASE TO THE PUBLIC								THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE IN THE CONFIDENTIALITY MARKING

RELEASED
2017-08-11
APPROVED

4.187



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042)			
Description Work Order Deviation		Disposition					
Root Cause		FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____					
		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐					
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐					
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					